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20NR-119-8
Job Sheet 190801

DAG
21
9-89



Part No: 20NR-119-8

Job Qty: 8 pcs

Part Name: Front Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/15/19

Job Tracking No:

Due Date: 3/1/19 *Apr 7*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-119-8 Rev.4 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	8 pcs	3/1/19	3/1/19	0.00	0.80	Waterjet - Omax		<i>de 19/03/20</i>
110	QC 2	8 pcs	3/1/19	3/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>de 19/03/20</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
120	QC 8	8 pcs	3/1/19	3/1/19	0.00	0.00	QC 8 - 12		

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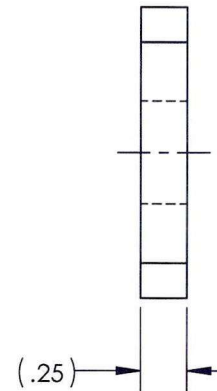
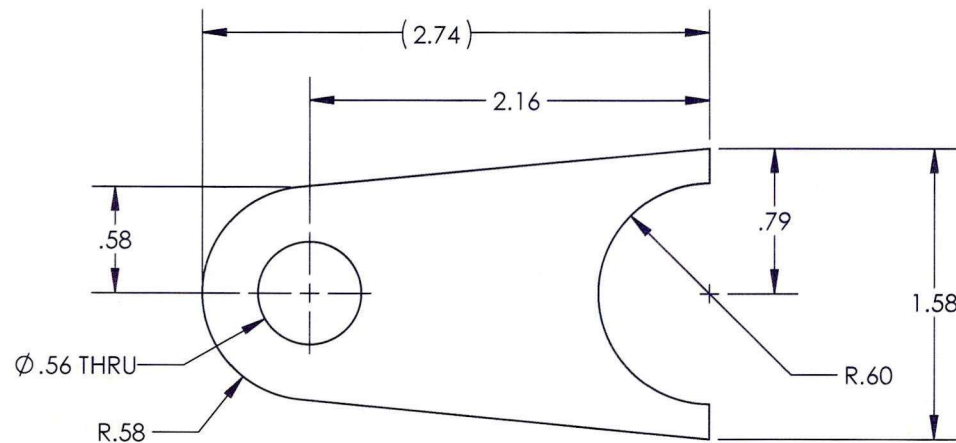
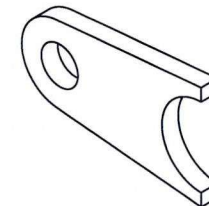
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	MAR 20 2019
				QC 8 - 68	DAS 40 9-89
130	Packaging 3-1 - Stock - B4B 8 pcs	3/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140	QC 21 - SA 8 pcs	3/1/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 9-89
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>4</u> PROG. Rev: <u>4</u> 2-Deburr if necessary Descriptions: 130 - .					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-HRS-P-0.250	Hot Rolled Steel Plate 0.250" (44W)	.2480 ft (.031 ea)	100-Waterjet - Omax - 1	5048044	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	MT-HRS-P-0.250	0	14	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	AS DRAWN BY CANAM	7/22/2013	CFS	
4	CH'D DIMENSION WAS 2.93 IS 2.74, WAS 2.35 IS 2.15, WAS Ø .54 IS Ø .60. MADE R.60 AND Ø.56 SYMMETRICAL.	6/18/2014	DJN	GE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 190801 MW
1902-15



USED ON
20NR-119
8NR-119
20NR-86
8NR-86

RED BARN MACHINE	
TITLE FRONT SUPPORT	
DWG NO. 20NR-119-8	REV 4
MAT'L 1018	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH SEE WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 12/1/1995
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-119-8	1	FRONT SUPPORT	1018	1/4 X 1-5/8 X 3-1/8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>190801</u> Part No. <u>20 NR-119-8</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date : <u>3/20/19</u>		Sequence #:		QTY Affected :		MRB (QS1042) <u>W</u>		
Description Work Order Deviation				Disposition				
DIMENSION WAS 1.58 IS 1.55 DIMENSION WAS R.60 IS Ø1.08				THIS DEVIATION IS ACCEPTABLE TO USE FIT FORM AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED				3/20/19
								Completed By
								Lead hand / Supervisor
QC / QA Coordinator								
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								



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Container No: S164256

Part: 20NR-119-8

Job No: 190801

Serial No/Batch: S164256

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 03/20/19